

41A1 Work Order ID 54684

December 16, 2009 10:45:39 AM

Page 1

Item ID: D3890-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Side

Start Date: 12/16/09 Start Qty: 1.00

Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *Ref*

Date: *9-12-16*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3890

A

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3890-1

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

AB 9-12-16

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 9-12-16

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Page 2

Item ID: D3890-041

Accept



Setup Start



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Stop



Item Name: Panel, Side

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> Serialing



130

0.00



Small Fab

Memo

0.00

Small Fab

Deburr if necessary

u/s

140

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Thermoform using mold DT9489 as per dwg

BOY/12/16
X1

Work Order ID 54684

Page 3

December 16, 2009 10:45:44 AM

Item ID: D3890-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Side

Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
160	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
170		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Bond gasket to smooth side of panel as per dwg A/R 3M 1300 adhesive Batch: M113174 = 7 m-l 09/12/17								

Work Order ID 54684

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Page 4

Item ID: D3890-041

Accept



Setup Start



Revision ID:

Item Name: Panel, Side

Stop



Start Date: 12/16/09 Start Qty: 1.00



Cust Item ID:

Required Date: 12/18/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

⇒ 802/12/17

HC

190



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

9/12/17 ID SP

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/12/21 HJ

SIAN
HAI

09/12/18

(1)

Picklist Print

December 16, 2009 10:45:38 AM

Page 1

Work Order ID: 54684

Parent Item: D3890-041

Parent Item Name: Panel, Side


Comments:

Start Date: 12/16/09

Required Date: 12/18/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04  GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	2,011.175	3.8084			

B 9-12-16

Warehouse
Location

Main Warehouse

	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	2011.175198	
103106	1.6765	
105330	47.8767	
109455	40.5717	
111710	329.893632	
112585	1591.15667	

D3890-3

Manufactured No

160

Each

0.0000

2.0000



Gasket

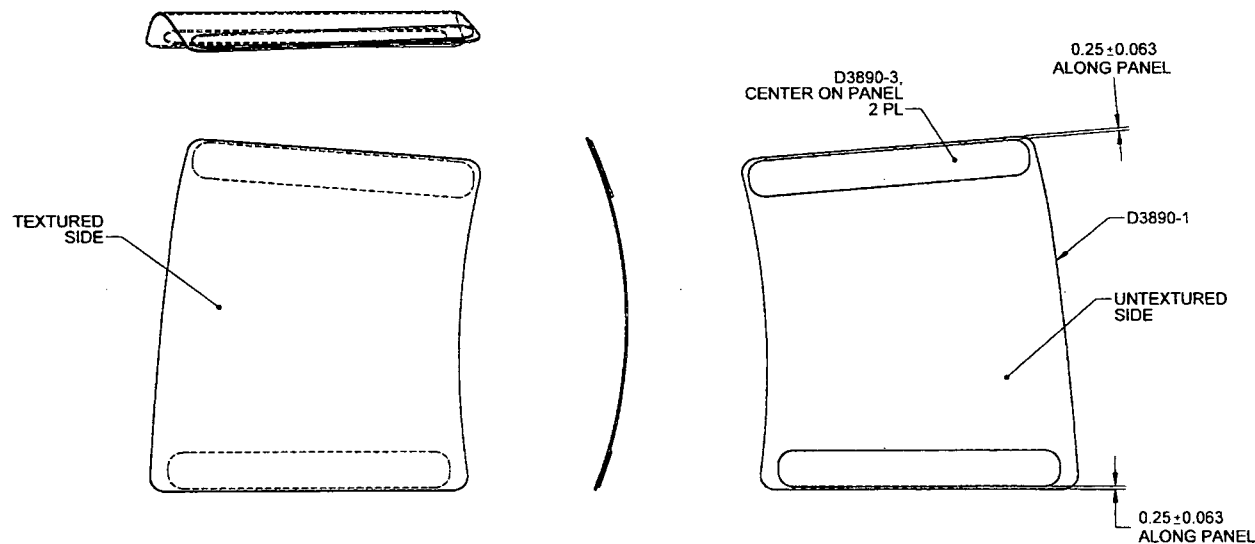
B 54688

112588

SB 09/12/17

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

**D3890-041 PANEL, SIDE**

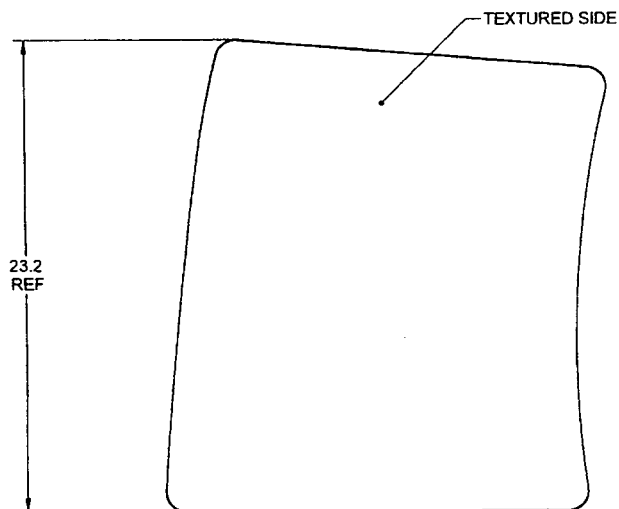
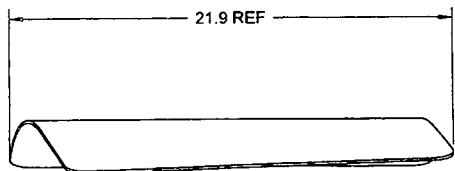
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

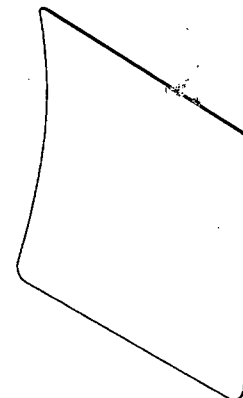
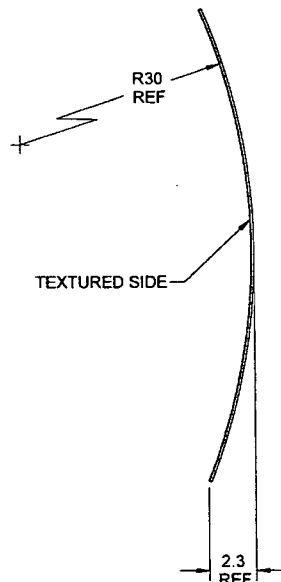
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34684
09-12-14

RELEASED
01/05/14

A	NEW ISSUE		CP	09.05.01
REV.	DESCRIPTION		BY	DATE
DESIGN	GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	GP			
CHECKED	PH		DRAWING NO.	REV.
MFG APPR.	PH		D3890	SHEET 1 OF
APPROVED	PH		TITLE	SCALE
DE APPR.	PH		PANEL, SIDE	NT
DATE	09.05.01		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3890-1 PANEL

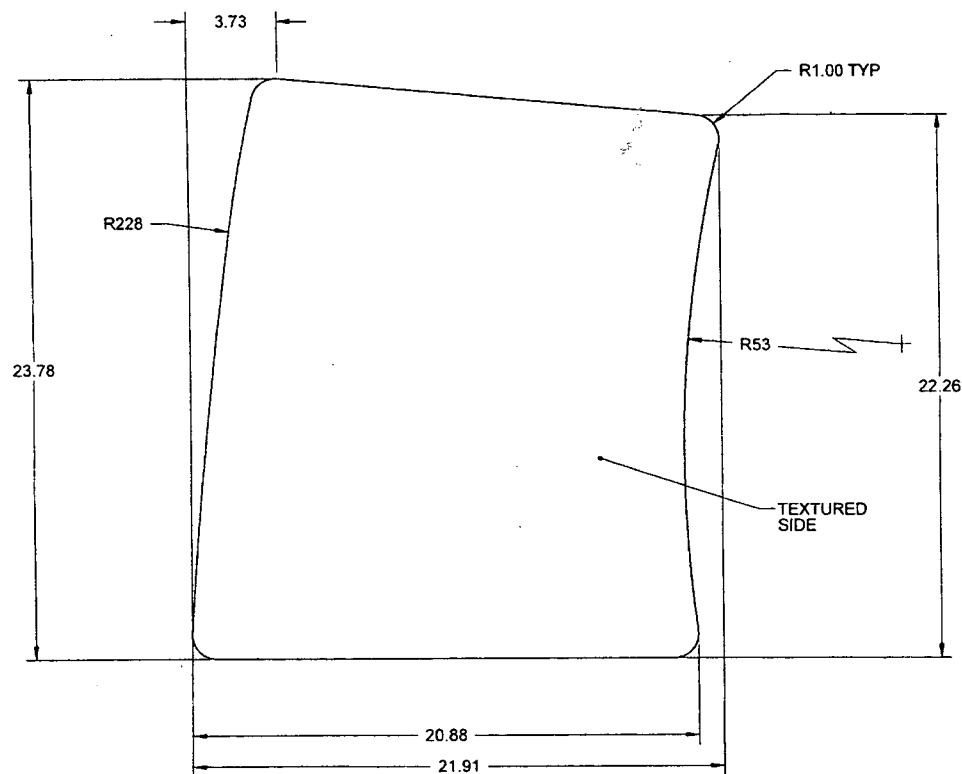


RELEASED
09/05/16

NOTES:

- 1) MATERIAL: MAKE FROM D3890-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs
- 8) THERMOFORM USING MOLD DT9489 PER QSI 022

DESIGN	97	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED	84		DRAWING NO. REV. A
MFG. APPR.	97		D3890 SHEET 2 OF 4
APPROVED	97		TITLE SCALE
DE APPR.	97		PANEL, SIDE NT
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D3890-1F PANEL

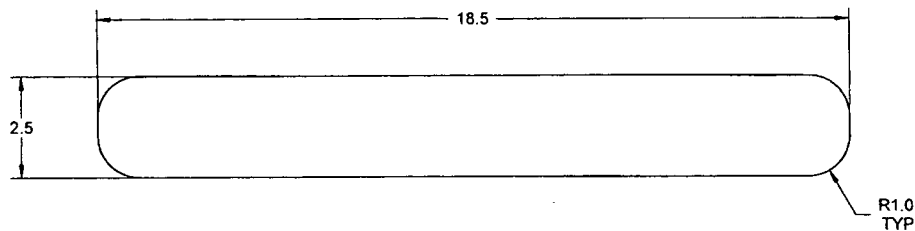
RELEASED
09/06/16

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

DESIGN	W10 54684	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 3 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.	14	PANEL, SIDE	NTS
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0.125
REF



D3890-3 GASKET

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
09/05/01

W/O 54684

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	21	D3890	SHEET 4 OF 4
APPROVED	142	TITLE	SCALE
DE APPR.	21	PANEL, SIDE	NTS
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